

32

Date: Monday, 7/16/2007 2:42:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH AFT X-TUBE 412  
 Job Number : 33540  
 Estimate Number : 10559  
 P.O. Number : N/A Part Number : D412664203  
 This Issue : 7/16/2007 S.O. No. : N/A Drawing Number : D412-664-243 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 33539 Material : N/A  
 Due Date : 8/5/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLM 07.07.17  
 Comment : Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS  
 Est Rev:F 06-03-29 Remove Comments on Pick List JLM  
 Est Rev:G 06.12.08 per ECN 886 EC  
 Est Rev:H 07-04-30 As per Rev D JLM

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07.07.30

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

S. 07/10/09

2.0 D6009129 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B.26548

Check OD = 3.500"; ID = 2.250"

JL 07/10/09

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

JL/J.F.

07/10/12

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JL/J.F. 07/10/12



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Seq. #: Machine Or Operation: Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243  
Cuff(Donot engrave on outside of tube)

Inside of

J.F. 07/10/12

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/12

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

and 07/10/14

(1)

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Jb 7-10-15

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/10/15

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Jb 7-10-22

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect work & Chemical conversion Coat

Er 07/10/23



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Job Number: 33540

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

CL 7-10-23

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

JA-10-24 (1)

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

SR/EL

07-10-24

JP 7-10-25

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JP 7-10-25

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JA 7/10/25

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA 7/11/26

18.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 49116 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL 7/11/26 (1)



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Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CS 07/10/30 ①

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

SA 07/10/30

21.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

} 85 07-10-31

2-Paint outside crosstube with White Imron as per QSI 005 4.2

22.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ml 07 10 01

23.0 D3595 Rubber Cushion (per sq ft)



Comment: Qty.: 0.0492 sf(s)/Unit Total : 0.0492 sf(s)

Rubber Cushion (per sq ft)

.630" x5.70" x2pcs

Batch: 33835

ml 07 11 05

24.0 D2856600 Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

25656

85 07-10-31

25.0 D28961 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

30200

ml 07 11 01



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Job Number: 33540

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 D31891 Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield

30201x1

~~30201~~

RT 07-10-31

27.0 MS2192028 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

104423

RT 07-10-31

28.0 MS2192030 clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 100154

MA 07 11 01

29.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

Time: 7:30 AM

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: MA 104677

Expiry Date: 04/08

MA 07 11 01

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

MA 07 11 05 (1)

30.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/9/06

31.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit



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Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description:

32.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: M10457

AS 07/11/07

33.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Bolt  
Batch: M100743 AS M101418

34.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)  
Washer  
Batch: M105125

AS 07/11/07

35.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Nut  
Batch: M104374

AS 07/11/07

36.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 07/11/07

37.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D412-664-203

\*\*\*\*\*Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date  
\*\*\*\*\*

Time & date of packaging:

07/11/07 @ 2:00pm S. 07/11/07

Location:

PPP Rev:

6 07/11/07



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Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Donna

Job Completion



u of 408



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 33540
<b>Description:</b> Crosstube Assembly (412 High Aft)	<b>Part Number:</b> D412-664-243
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688"	✓			
	2.748	+0.005/-0.000	2.752"	✓			
	2.884	+0.005/-0.000	3.887"	✓			
	3.019	+0.005/-0.000	3.021"	✓			
	3.163	+0.005/-0.000	3.164"	✓			
	3.308	+0.005/-0.000	3.311"	✓			
	3.429	+0.005/-0.000	3.432"	✓			
	2.990	+0.005/-0.000	2.994"	✓			
	2.618	+0.005/-0.000	2.621"	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	0.063	✓			
	R0.500	+/-0.010	0.500	✓			
	4.971	+/-0.030	4.978"	✓			
	2.684	+0.005/-0.000	2.688"	✓			
	2.748	+0.005/-0.000	2.753"	✓			
	2.884	+0.005/-0.000	2.888"	✓			
	3.019	+0.005/-0.000	3.022"	✓			
	3.163	+0.005/-0.000	3.165"	✓			
	3.308	+0.005/-0.000	3.311"	✓			
	3.429	+0.005/-0.000	3.432"	✓			
	2.990	+0.005/-0.000	2.994"	✓			
	2.618	+0.005/-0.000	2.621"	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	0.063	✓			
	R0.500	+/-0.010	0.500	✓			
	4.971	+/-0.030	4.975"	✓			
	124.09	+/-0.020	124.09	✓			

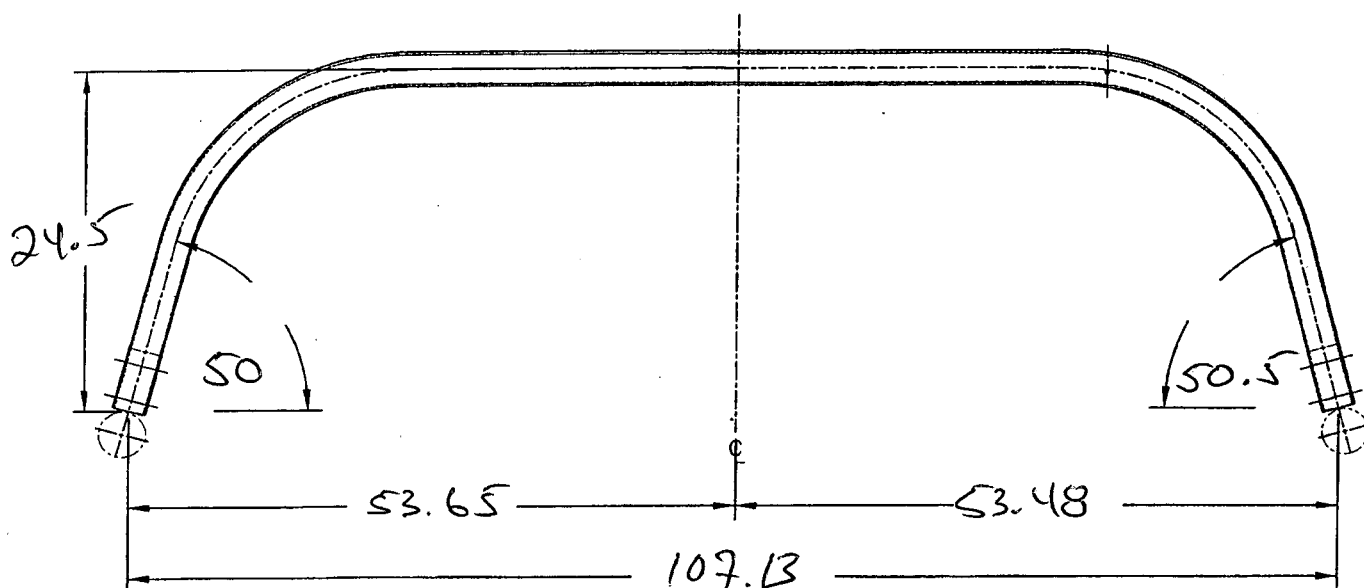
<b>Measured by:</b> J.L./J.F.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/10/12	<b>Date:</b> 07/10/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	33540
<b>Description:</b> Crosstube High Aft (412)	<b>Part Number:</b>	D412-664-203
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> D		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
✓ Tube is even on the height.

QC15 Inspection	2051012
Date	07-10-24

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	



**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>QP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

**RELEASE**07.04.24 **[Signature]**

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

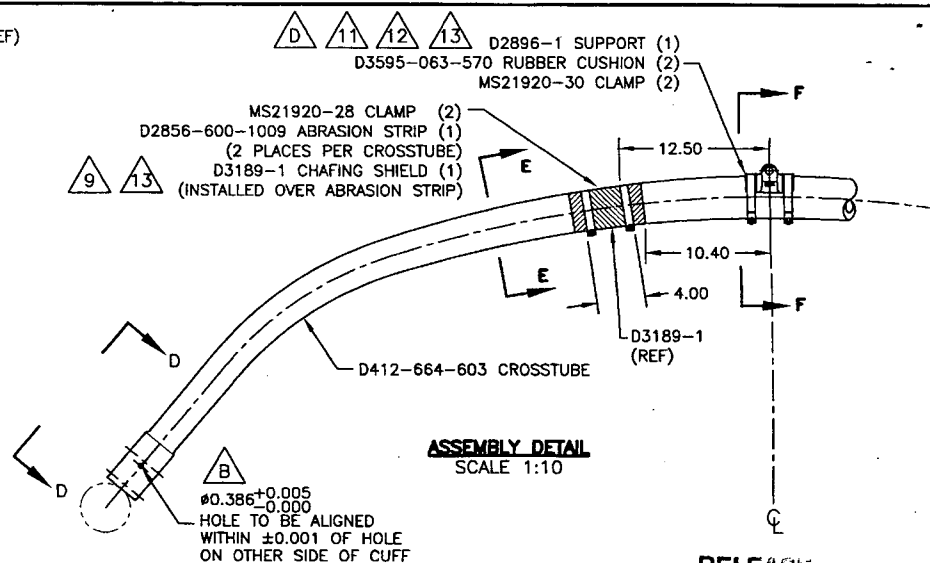
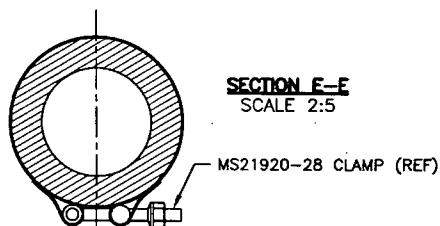
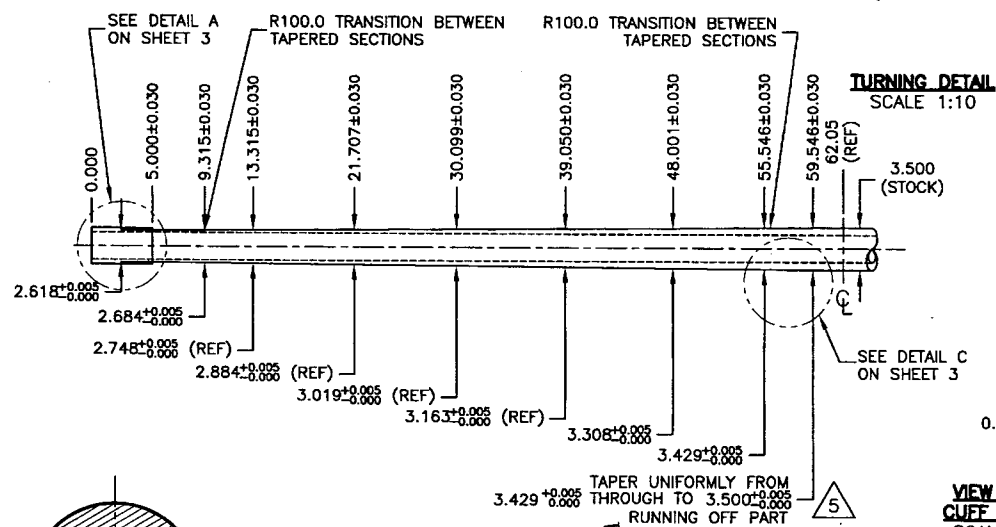
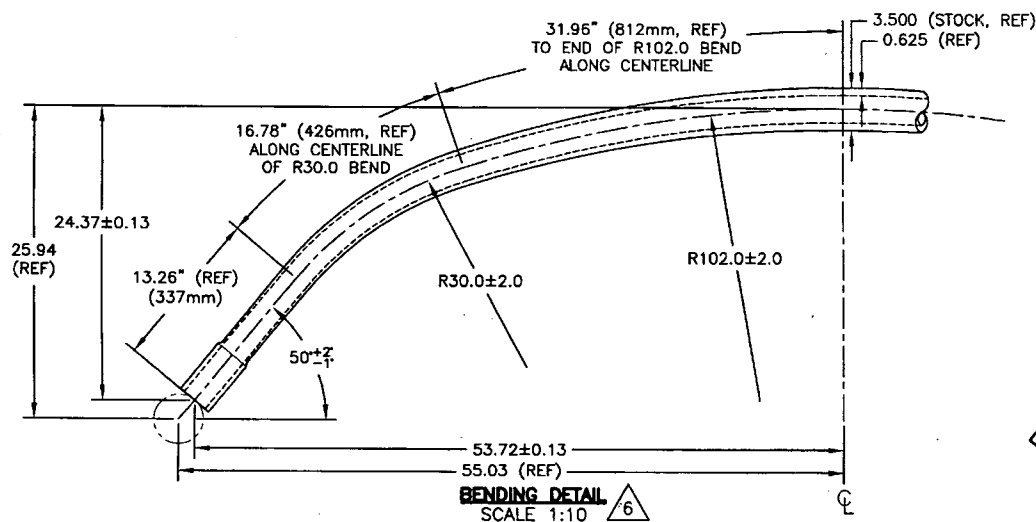
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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NO. **33540**

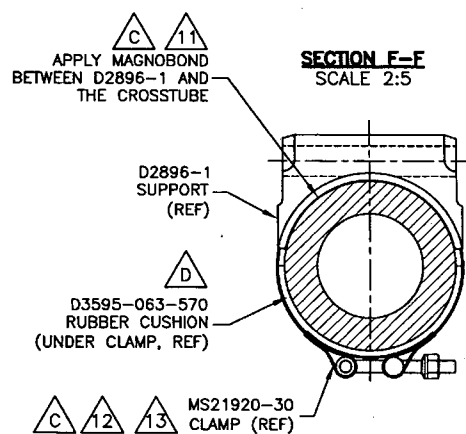
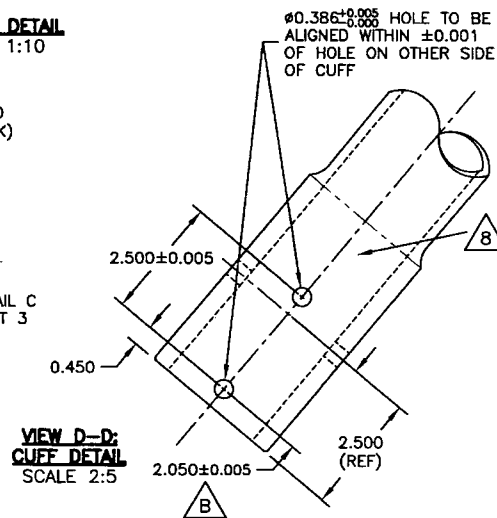
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RELEASE  
07.04.24



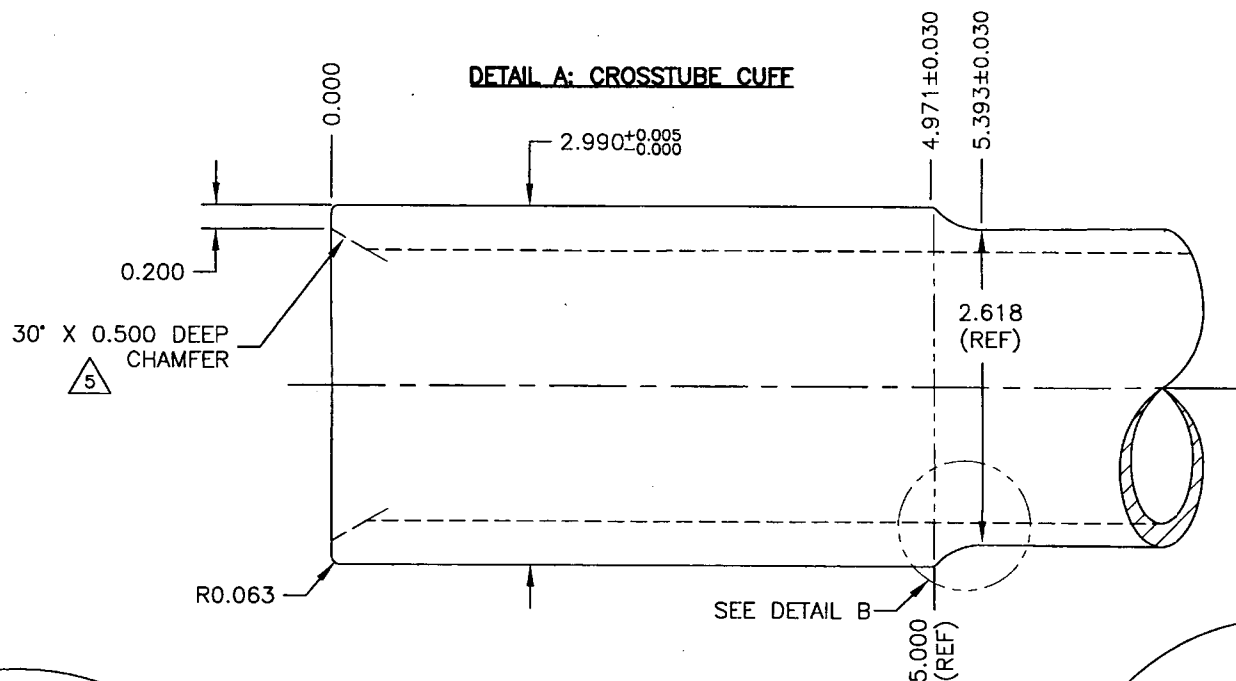
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	GP	APPROVED	PH		
DATE		07.03.09		DRAWING NO.		D412-664-243	SHEET 2 OF 3
				TITLE		CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:10

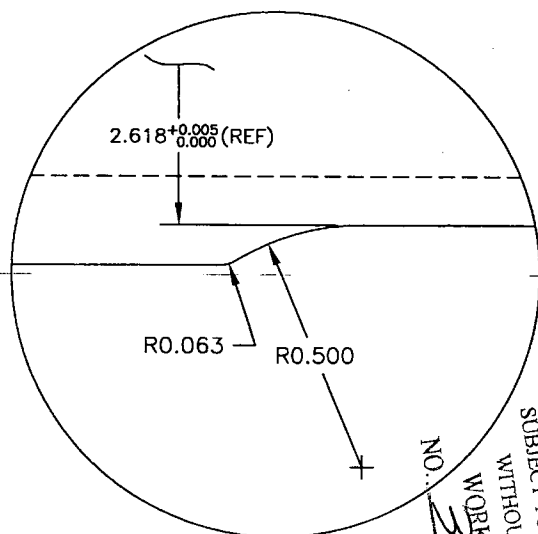


**RELEASED**  
07-04-244P  
PER ECN 009

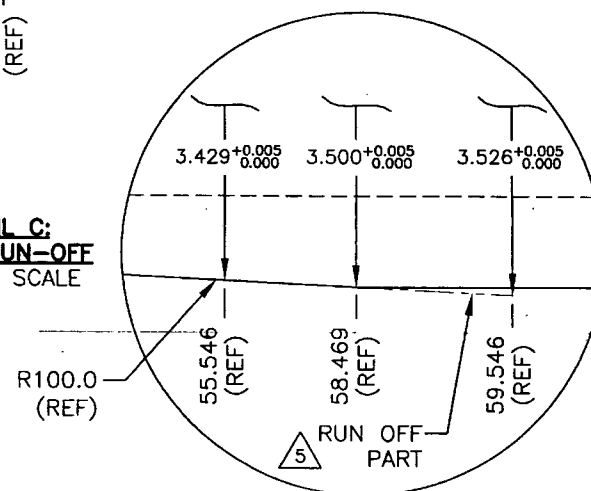
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
TRANSITION**  
SCALE 4:1



**DETAIL C:  
TAPER RUN-OFF**  
NOT TO SCALE



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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED J	APPROVED J	DRAWING NO. D412-664-243	REV. D SHEET 3 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1





P. 09852

PAGE 1 OF 1  
TIME AM ☒ PM ☐

CLIENT	Def Aerospace	DATE	Oct 26/07	TIME	AM <input checked="" type="checkbox"/> PM <input type="checkbox"/>
ATTENTION	Linda Lacelle	ACUREN JOB No.	188-07-C1174		
ADDRESS	1370 Aberdeen St Hawkesbury, ON	PO/WO No.	4916		
		WORK LOCATION	Hawkesbury		
		ACCEPTANCE STD.	ASTM 1417/051-078	REV./DATE	2005
PROJECT	Flourescent Liquid Pent. on 212/205 High FED X-TUBE + High AFT X-TUBE 412				
ITEM(S) EXAMINED	JOB# 33540 Part# D412664203 + JOB# 33539 + JOB# 35055 + JOB# 35056 + JOB# 35106 Also - JOB# 34928 Part# - D212664101				

JOB DESCRIPTION	PROCEDURE NO. LT-0002 REV./DATE	TECHNIQUE NO. LT-TECH#2 REV./DATE
PART NO. D412664203 / D212664101	MATERIAL Alodined Alum.	THICKNESS
SCOPE Wet Fluorescent Liquid Penetrant Inspection. 100% external surface.		

METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE		<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED	
FAMILY BRAND <u>Magnaflux</u>		BLACK LIGHT S/N <u>3163</u> <input type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup> <input type="checkbox"/> AMBIENT < 2 fc	
PENETRANT <u>ZL-67</u>	MINIMUM DWELL TIME <u>10-15</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
PENETRANT REMOVER <u>H2O</u>	MINIMUM DRY TIME > 10 MIN.	OTHER <u>CAL DUE DATE - APR 17-08</u>	
DEVELOPER <u>SKD-32</u>	MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N _____ CAL DUE DATE _____	
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY			

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F		<input type="checkbox"/> > 52°C/125°F

[illegible]

### Scope of Services

the agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

### Standard of Care

7 performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE <u>James Hurdock</u>		DTR # <u>27455</u>	
TECHNICIAN (SIGNATURE): <u>[Signature]</u>		REPORT REVIEWED BY:	
NAME (PRINT): <u>PAFFONAK</u>		NAME INITIALS	
1 <sup>ST</sup> TECHNICIAN		2 <sup>ND</sup> TECHNICIAN	
CGSB LEVEL <u>II</u> SNT LEVEL <u>II</u>		CGSB LEVEL _____ SNT LEVEL _____	
CGSB REG. NO <u>33887</u>		CGSB REG. NO _____	

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ACUREN

## LIQUID PENETRANT TEST REPORT

P- 09853

CLIENT	<u>Dart Aerospace</u>	DATE	<u>Oct 30-07</u>	PAGE	<u>1</u> OF <u>1</u>
ATTENTION	<u>Linda Lacelle</u>	ACUREN JOB NO.	<u>188-07-011</u>	TIME	AM <input checked="" type="checkbox"/> PM <input type="checkbox"/>
ADDRESS	<u>1270 Aberdeen St.</u>	PO/VO No.	<u>4916</u>		
	<u>Hawkesbury, ON.</u>	WORK LOCATION	<u>DART Aerospace</u>		
PROJECT	LPI - Fluorescent on 212/305 HIGH FED X+TUBE+HIGH AFT-X-TUBE 412				
ITEM(S) EXAMINED	JOB# - 34928; + 35106; 35056; 35055; 33540; 33539;				

JOB DESCRIPTION	PROCEDURE NO. <u>LT 8002</u> REV./DATE	TECHNIQUE NO. <u>2LT-XXXX-XXX</u> REV./DATE
PART NO. <u>D412664203 / D212664101</u>	MATERIAL <u>Alodined Alumin.</u>	THICKNESS
SCOPE <u>Wet-LPI-Fluorescent - 100% external surface</u>		

TEST DETAILS	
METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND <u>Magnaflux</u>	BLACK LIGHT S/N <u>8168</u> <input checked="" type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup> <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT <u>ZL-567</u> MINIMUM DWELL TIME <u>10-15</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER <u>H<sub>2</sub>O</u> MINIMUM DRY TIME <u>&gt;10</u> MIN.	OTHER <u>CAL DUE DATE - APR 17-08</u>
DEVELOPER <u>SKD-32</u> MINIMUM DWELL TIME <u>10</u> MIN.	LIGHT METER S/N CAL DUE DATE
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	

TEST SURFACE	
SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL	
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F	

RESULTS- <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL	
ITEM	COMMENTS
	All above items were - re-inspected after indications & scratches were removed - (See Report # 09852); No relevant indications noted @ time of inspection
ACCEPT	REJECT

**Scope of Services**  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

**Standard of Care**  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	DTR # <u>27466</u>
TECHNICIAN (SIGNATURE)	REPORT REVIEWED BY:
NAME (PRINT): <u>PAT PUNAK</u>	NAME INITIALS
CGSB LEVEL <u>II</u> SNT LEVEL <u>II</u> CGSB REG. NO. <u>3387</u>	2 <sup>ND</sup> TECHNICIAN

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CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY




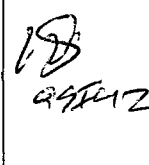
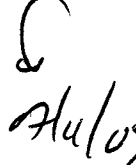
PT Sept 2005



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQALD Date: 07/11/09

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/06	26.0	Chafing shield was bent and squeezed all around human error	 09/01/06	Remove chafing shield and replace with new one.	 07/11/06	 07/11/09	 09/01/06	 07/11/09

NOTE: Date & initial all entries